

Work Order ID 73886

Friday, September 16, 2011 3:27:07 PM

Page 1

Item ID: D206-642-151

Revision ID:

Item Name: Replacement Skidtube

Start Date: 9/16/2011 Start Qty: 1.00

Required Date: 10/21/2011 Req'd Qty: 1.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 11-09-19 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110



Skidtubes

Skidtubes

Skidtubes

Memo

1-Debur Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐ M112860

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Debur

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

DC / DD

11/09/20

BE 11/09/20

DD 11-9-20

MO/BB 11-9-21

BB 11/09/22

DD 11-9-23

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

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Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Sudo 9/26

FD

11-9-23

MO/SD 11-9-27

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| | HandFinish | | | | | | | | |
| Hand Finishing | Memo | 0.00 | | | | | | | |
| 150 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| | QC | | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |
| 160 | Skidtubes | 0.00 | | | | | | | |
| | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| | 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) | | | | | | | | |
| | 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) | | | | | | | | |
| | 3-Deburr and blow out all chips from inside the tube | | | | | | | | |

TW

11-09-28

DP

11-9-28

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11/09/28

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

11-9-28

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

OK 11/09/28

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☐ 11/09/28 ☐ Time: ☐ 2:00 ☐Finish Date: ☐ ☐ Time: ☐

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch
A/R ☐ Sikaflex-291 ☐ 118392 ☐Sikaflex expire date: ☐ 12/04/05

OK 11/09/28

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DD 11-9-29

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐ 117384

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

de/ol 11/09/29, 11/09/29

11.09.29
11/10/01

11/10/03

11-10-04

| W/O: | | WORK ORDER CHANGES | | | | | |
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Accept



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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210



HandFinish
Hand Finishing

HandFinishing

Memo

Install D2680-041 Nut Plate as per Dwg D3804

0.00

0.00

DP

11-10-04

220



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

Sukolay

QC9

11-10-04

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sukolay

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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

1:00
320 OF
1:30

IXD M-11/10/06

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d M 11/10/06

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CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

1 4 11/10/07

280

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
A/R ☐ Sikaflex-291 ☒ M11839B
Sikaflex expire date: ☐ 12/05

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: M1183B

1 4 11/10/07

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Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

S u/holo

300



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

*S u/holo**hH*

310



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev: *PPP 74401**Peng/1/12*

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Accept



Setup Start



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Stop



Item Name: Replacement Skidtube

Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 320 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
|  | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

11/10/2011
MF
11-10-19

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 73886

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube




Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC IPP
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2620  Skidtube, 206 Skidtube | | Manufactured | No | | | 110 | Each | 12.0000 | 1 | 1 | | | |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> | | | | | | | | | | | | | |
| <div> <div>LG</div> <div>12</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>68136</div> <div>1</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>71616</div> <div>5</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>71617</div> <div>6</div> <div></div> </div> | | | | | | | | | | | | | |
| D2647  Cap | | Manufactured | No | | | 110 | Each | 44.0000 | 1 | 1 | | | |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> | | | | | | | | | | | | | |
| <div> <div>LG002</div> <div>44</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>55352</div> <div>14</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>71171</div> <div>30</div> <div></div> </div> | | | | | | | | | | | | | |
| CR3212-4-04  Cherry Rivet | | Purchased | No | | | 180 | Each | 1,655.000 | 52 | 52 | | | |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> | | | | | | | | | | | | | |
| <div> <div>ST311</div> <div>1655</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>116471</div> <div>78</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>117816</div> <div>477</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>118686</div> <div>100</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>118840</div> <div>1000</div> <div></div> </div> | | | | | | | | | | | | | |

73787
11/09/20

8611/09/20

11/09/20

30
23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: I/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 3:27:03 PM

Page 2

Work Order ID: 73886

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1

Manufactured No

180

Each

6.0000

1

1



Web

Location

Loc Qty

Loc Code

LG

73789

6

64562

6

180

Each

32.0000

2

2

D3286-1

Manufactured No



Doubler

Location

Loc Qty

Loc Code

LG002

32

52844

11

64563

21

200

Each

289.0000

19

19

D2649

Manufactured No



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

373857

6

68224

2

71355

2

72704

2

LG001

283

65317

1

68507

11

73390

271

200

Each

27.0000

2

2

D3286-3

Manufactured No



Spacer

B74117

Location

Loc Qty

Loc Code

LG002

27

64564

27

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 3:27:04 PM

Page 3

Work Order ID: 73886

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

210

Each

19.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

ST020

B73334

19

55366

17

70088

2

① DP 11-10-4

CR3212-4-03

Purchased

No

210

Each

1,138.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1136

114859

1136

② DP 11-10-4

AN960JD416

NAS1149D04631

Purchased

No

210

Each

0.0000

1

1



Washer

CCR264SS3-3

Purchased

No

210

Each

435.0000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

433

117086

23

117849

410

② DP 11-10-4

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73886

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

29.0000

1

1



Screw



20 11/10/07

Location

Loc Qty

Loc Code

FP-A

8

115460

8

ST292

21

115460

21

D2651-1

Manufactured

No

270

Each

289.0000

6

6



Plug



24 11/10/07

Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

D2651-3

Manufactured

No

270

Each

799.0000

6

6



O-Ring



24 11/10/07

Location

Loc Qty

Loc Code

FP-A

799

61962

12

66956

282

73489

505

24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 3:27:04 PM

Page 5

Work Order ID: 73886

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280

Each

160.0000

14

14



Bushing



del 11/10/07

Location

Loc Qty

Loc Code

ST084

4

B75829

x 14

68247

4

ST088

156

64760

1

70690

54

71837

101

D2646

Manufactured No

280

Each

89.0000

1

1



Aft Cap



del 11/10/07

Location

Loc Qty

Loc Code

FP004

45

68280

45

FP006

5

62678

5

FP-4

35

70945

1

71070

34

fp5

4

71038

4

x 1

D3805-041

Manufactured No

280

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear

B73770



del 11/10/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 3:27:05 PM

Page 6

Work Order ID: 73886

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,296.000

2



Screw



2
JL 11/10/07

Location

Loc Qty

Loc Code

ST291

1296

115108

96

117423

300

118378

400

118910

500

✓

MS21042L3

Purchased

No

280

Each

2,603.000

7



Nut



7
JL 11/10/07

Location

Loc Qty

Loc Code

ST300

2603

117441

24

117601

374

117885

205

118451

1000

118927

1000

✓

D3805-045

Manufactured

No

280

Each

6.0000

1



Wearplate Assembly Aft, Low Gear



1
JL 11/10/07

Location

Loc Qty

Loc Code

FP

6

70878

6

B73771

✓

AN960JD10L

NAS1149D03321

Purchased

No

280

Each

0.0000

2



Washer



2
117087 (42) JL 11/10/07

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 3:27:05 PM

Page 7

Work Order ID: 73886

Parent Item: D206-642-151


Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No 280 Each 261.0000 7 7

 Bolt

Location Loc Qty Loc Code


ST353 211

111668 111

118628 100

ST354 50

117619 50

NAS1149D0363J Purchased No 280 Each 2,623.000 7 7

 Washer

Location Loc Qty Loc Code

ST298 2623

117601 308

118077 1315

118612 1000

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | Qty -041 | Qty -043 | Part Number | Description |
|------|-------------|-------------|--------------|---------------------------------|
| 1 | X | | D3804-041 | SKIDTUBE ASSEMBLY, 206 A/B LOW |
| 2 | | X | D3804-043 | SKIDTUBE ASSEMBLY, 206 A/B HIGH |
| 5 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 6 | 1 | 1 | D2646 | AFT CAP |
| 7 | 1 | 1 | D2647 | CAP |
| 8 | 19 | 20 | D2649 | CROSS BOLT SPACER |
| 9 | 6 | 8 | D2651-1 | PLUG |
| 10 | 6 | 8 | D2651-3 | O-RING |
| 11 | | 1 | D2654-3 | WEB |
| 12 | 1 | | D2654-1 | WEB |
| 13 | 1 | 1 | D2680-041 | NUT PLATE |
| 14 | 2 | 2 | D3286-1 | DOUBLER |
| 15 | 2 | 2 | D3286-3 | STUD |
| 21 | 2 | 2 | AN960JD10L | WASHER |
| 22 | 1 | 1 | AN960JD416 | WASHER |
| 23 | 2 | 2 | CCR264SS3-3 | RIVET |
| 24 | 2 | 2 | CR3212-4-03 | RIVET |
| 25 | 52 | 52 | CR3212-4-04 | RIVET |
| 26 | 2 | 2 | MS27039-1-08 | SCREW |
| 27 | 1 | 1 | MS27039-4-06 | SCREW |

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER
DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5
INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE
BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN
THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

#73886

RELEASED

09.03.03
per ECN 09-536

| | | | |
|------------|-------------|--|--------------|
| A | NEW ISSUE | MB | 08.07.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 98 | PORT HADLOCK, WA | |
| CHECKED | 99 | DRAWING NO. | REV. A |
| MFG. APPR. | 100 | D3804 | SHEET 1 OF 5 |
| APPROVED | 101 | TITLE | SCALE |
| DE APPR. | 102 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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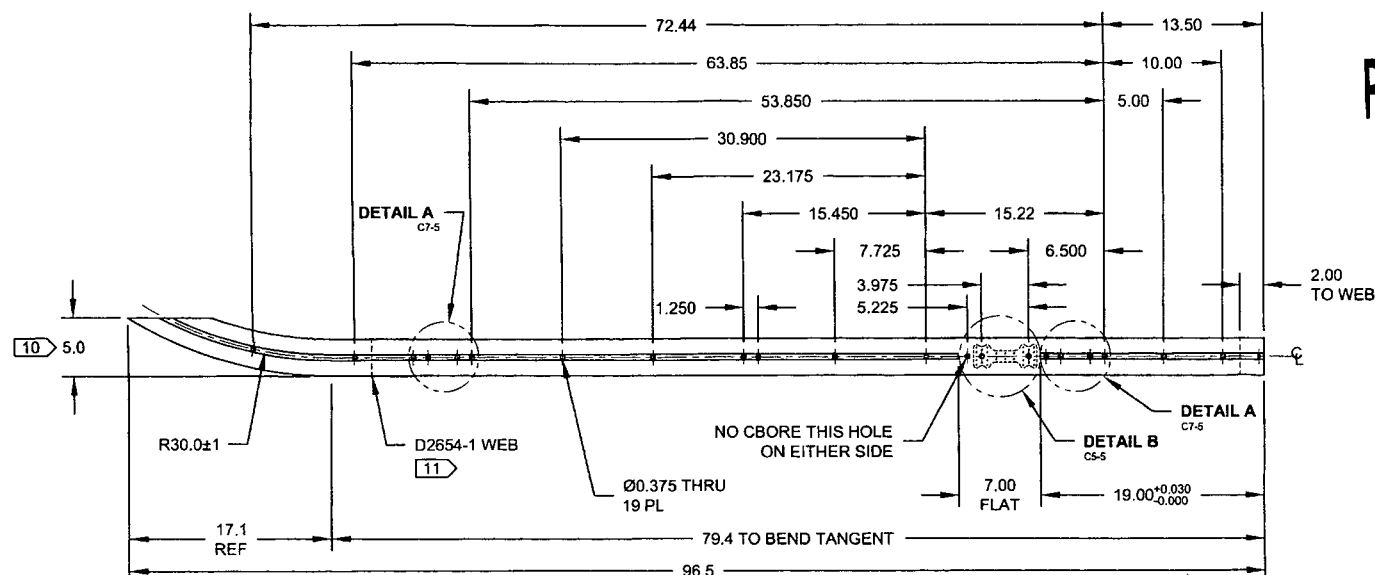
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

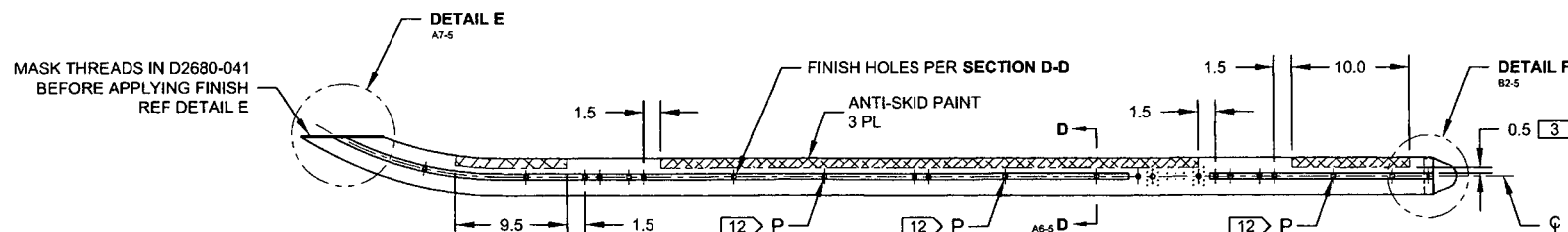
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NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

| | | | |
|------------|----------|--|--------------|
| DESIGN | 99 | DART AEROSPACE USA, INC | |
| DRAWN | 99 | PORT HADLOCK, WA | |
| CHECKED | 99 | DRAWING NO. | REV. A |
| MFG. APPR. | 99 | D3804 | SHEET 2 OF 5 |
| APPROVED | 99 | TITLE | SCALE |
| DE APPR. | 99 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

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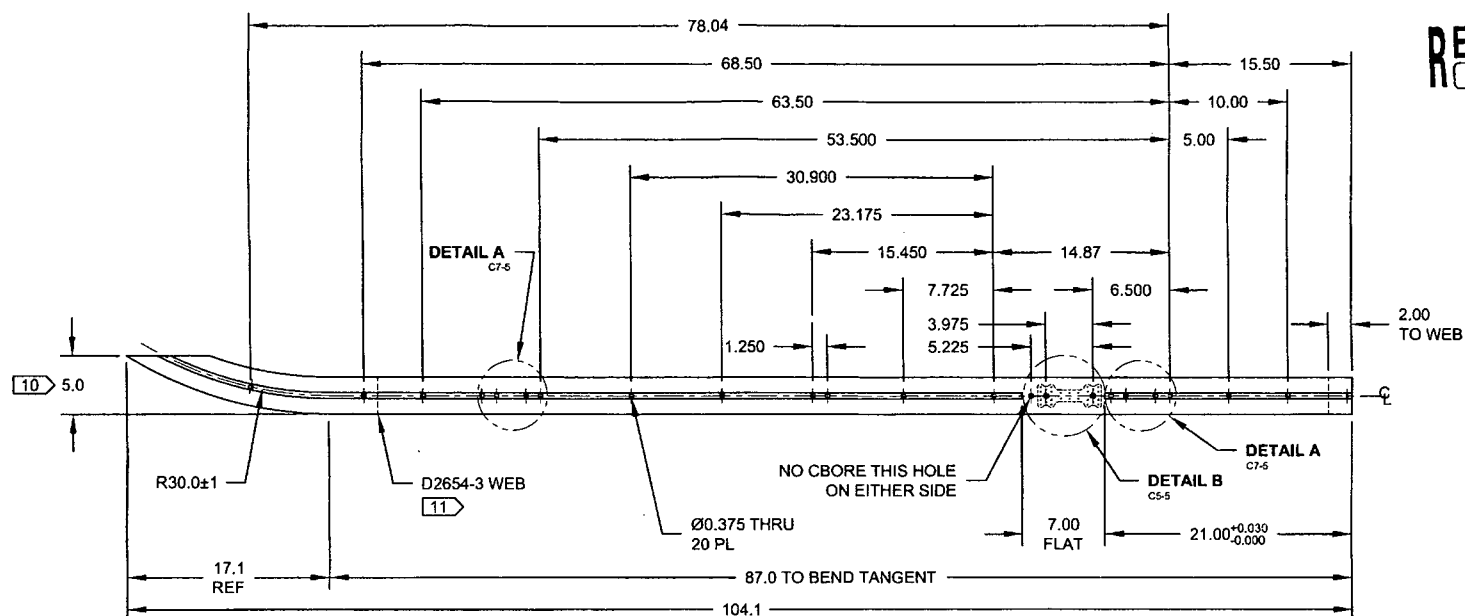
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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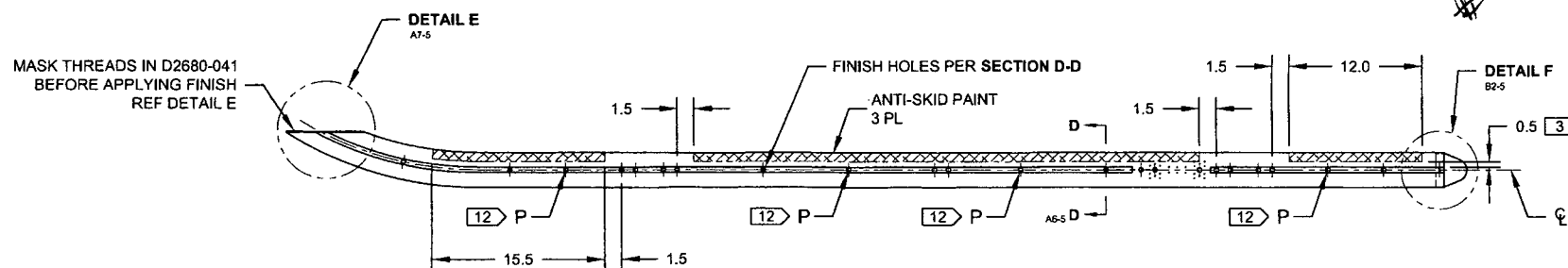
NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-043 BENDING/DRILLING DETAIL

73856



D3804-043 ASSEMBLY/FINISHING DETAIL

| | | | |
|------------|----------|--------------------------------|--------------|
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 97 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 97 | D3804 | SHEET 3 OF 5 |
| DE APPR. | 97 | TITLE | SCALE |
| DATE | 08.07.07 | SKIDTUBE ASSEMBLY, 206A/B | NTS |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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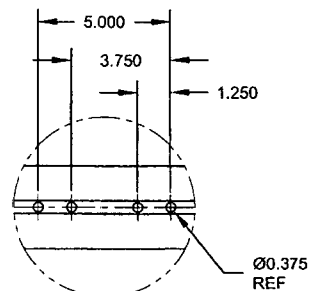
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

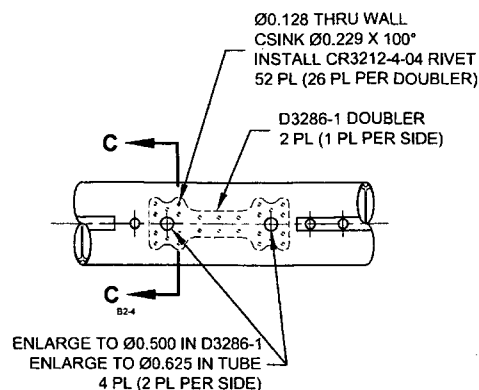
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

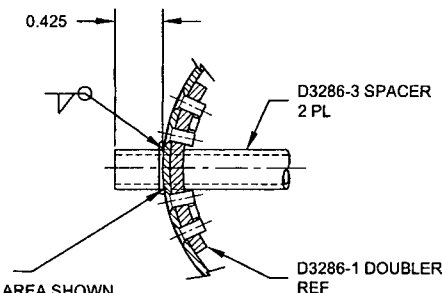
RELEASED
UP 09.03.03



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

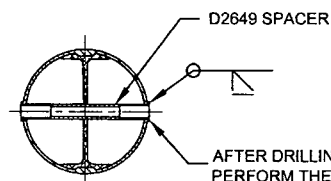


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

| | | | |
|------------|----------|--|--------------|
| DESIGN | 99 | DART AEROSPACE USA, INC | |
| DRAWN | 99 | PORT HADLOCK, WA | |
| CHECKED | 99 | DRAWING NO. | REV. A |
| MFG. APPR. | 99 | D3804 | SHEET 4 OF 5 |
| APPROVED | 99 | TITLE | SCALE |
| DE APPR. | 99 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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#73886

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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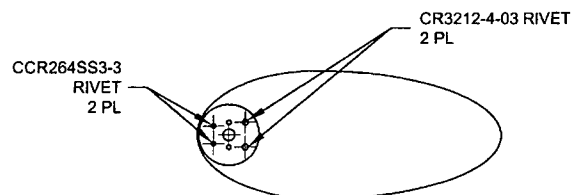
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

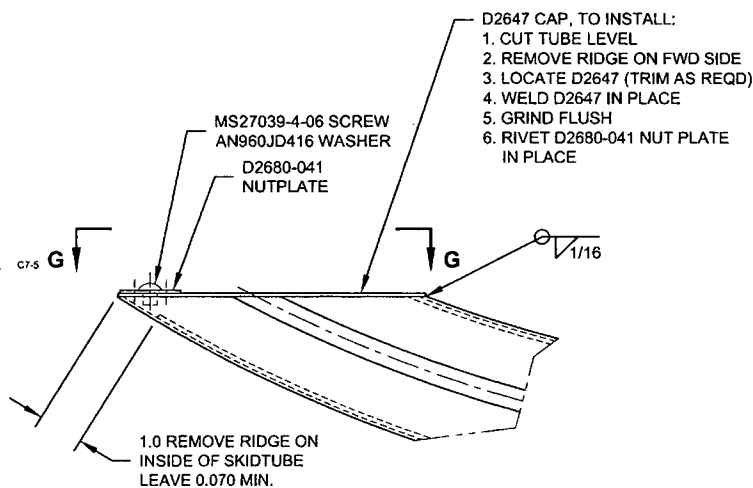
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NOTE: Date & initial all entries

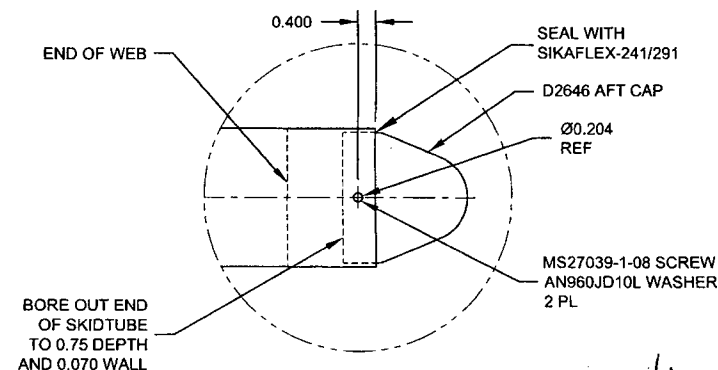
RELEASED
09 03 03



VIEW G-G
SCALE NONE



DETAIL E
SCALE NONE



DETAIL F
SCALE NONE

#73864

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|------------|----------|--|--------------|
| DESIGN | 91 | DART AEROSPACE USA, INC | |
| DRAWN | 91 | PORT HADLOCK, WA | |
| CHECKED | 91 | DRAWING NO. | REV. A |
| MFG. APPR. | 91 | D3804 | SHEET 5 OF 5 |
| APPROVED | 91 | TITLE | SCALE |
| DE APPR. | 91 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 268

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Art Ewers
Job number: B73883
Part number: A206-G42-151
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Samir Amwal Date of Test Coupon 11.10.04
Welder Art Ewers Date of Test Coupon 11.10.04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld